

Work Order ID **77185*****77185***

Page 1

November-28-11 9:05:07 AM

Item ID: K10003

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, D205-634-011

Start Date: 28/11/2011 Start Qty: 5.00

5

Cust Item ID:

Required Date: 12/12/2011 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLJDate: 11/11/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN634,635

Rev F

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Create White labels only per PPP K10003 CHG 007

MLJ 11-12-12 (5)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

SP 11-12-06

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

11-12-12 (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77185

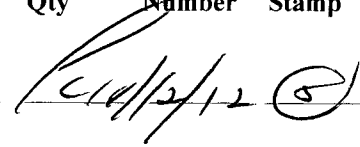
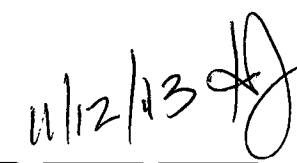
77185

Page 2

November-28-11 9:05:07 AM

Item ID: K10003 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Saddle, D205-634-011
 Start Date: 28/11/2011 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 12/12/2011 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo <i>P/116</i>	0.00							<i>11/12/12</i> 
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>11/12/13</i> 
Quality Control									<i>ME</i> <i>11-12-13</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-28-11 9:05:10 AM

Page 1

Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: I 03.01.16 Reformat: Incorporated D205-641-011 KJ/RF
 IPP: J 06-07-25 As per DSI 9344 JLM
 IPP: K 06.11.17 Per K10003 Rev C KJ
 IPP: L 07.01.12 Document Record for copying bluefile rmv KJ
 IPP Rev:M 08-08-12 now @ chg 006 (DSI 9418) DD verified by:
 IPP N 09.01.27 DSI 9418 rev B EC verified by: DD IPP Rev:O
 11.03.11 per dsi9536 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-51A *AN4-51A* Bolt		Purchased	No			110	Each	124.0000	8	40			
** m 119788. SP. 40x.													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST361		124								
			118706		50								
			118983		24								
			119127		50								
AN4-6A *AN4-6A* Bolt		Purchased	No			110	Each	4,574.000	16	80			
** SP.													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST516		4574								
			119017		4574				80x				
AN4C46A *AN4C.46A* BOLT		Purchased	No			110	Each	26.0000	4	20			
** SP 11-12-07 m 119849. 14x.													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			ST086		1								
			107287		1								
			ST360		25								
			119745		25				6x				

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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November-28-11 9:05:10 AM

Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

AN6-12A Purchased No

110 Each 71.0000 8 40

AN6-12A

Bolt

**

SP m/11/99 34 6x
PC

Location

Loc Qty

Loc Code

ST341

71

119127

21

119749

50

34X.

AN960JD416 Purchased No

110 Each 0.0000 32 160

AN960.ID416

Washer

**

m/119075 SP

AN960JD616 Purchased No

110 Each 0.0000 8 40

AN960.ID616

Washer

**

m/119075 Sp.

D2570 Manufactured No

110 Each 82.0000 24 120

D2570

Bushing

**

80 8x
B 77216 SP.

Location

Loc Qty

Loc Code

ST017

82

66933

1

67759

14

72122

1

72960

41

74868

25

1

Manufactured No

110 Each 6.0000 1 5

D2571

Saddle, Fwd Out 205

**

SP 11-12-07
B 76438 4x.

Location

Loc Qty

Loc Code

ST

6

11644

0

76375

6

1x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D2572
D2572
Saddle, Fwd In 205

Manufactured No

110

Each

3.0000

1

5

**

B 76442 SP.

Location

Loc Qty

Loc Code

ST433

2

71107

2

ST444

1

76376

1

D2573
D2573
Saddle, Aft Out 205

Manufactured No

110

Each

2.0000

1

5

**

B 76451 SP.

Location

Loc Qty

Loc Code

ST

1

76377

1

ST423

-11

73682

1

ST434

12

D2574
D2574
Saddle, Aft In 205

Manufactured No

110

Each

2.0000

1

5

**

B 76439 SP.

Location

Loc Qty

Loc Code

ST425

1

73684

1

ST434

1

76378

1

D2747
D2747
Set Screw

Manufactured No

110

Each

66.0000

4

20

**

SP 11-12-07.

Location

Loc Qty

Loc Code

ST021

66

73495

66

November-28-11 9:05:10 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November-28-11 9:05:10 AM

Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D2876
D2876
Saddle Spacer

Manufactured No 110 Each 27.0000 2 10

**

SP.

Location Loc Qty Loc Code

ST025 27
73308 27

Manufactured No 110 Each 57.0000 2 10

**

10x
10

SP.

Location Loc Qty Loc Code

ST025 57
73309 57

Manufactured No 110 Each 5.0000 1 5

**

10x
5

B76218 SP.

Location Loc Qty Loc Code

ST474 3
62227 2
68970 1
ST748 2
74549 2

Manufactured No 110 Each 6.0000 1 5

**

B76221 SP
11-12-06

Location Loc Qty Loc Code

ST423 2
65703 2
ST478 4
68343 1
74550 3

D3405-043
D3405-043
Lug Assembly

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

November-28-11 9:05:11 AM

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Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

D3407-041

D3407-041

Tow Ring

Manufactured No

110

Each

10.0000

1

5

**

SP.

Location

Loc Qty

Loc Code

ST463

10

75029

10

5x

Manufactured No

110

Each

45.0000

2

10

**

SP

Location

Loc Qty

Loc Code

ST053

45

73326

5

75044

40

10x

Manufactured No

110

Each

61.0000

1

**

SP.

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

54

66848

3

71165

2

73493

49

5x

Manufactured No

110

Each

54.0000

2

10

**

SP 11-12-06

Location

Loc Qty

Loc Code

ST065

54

73310

54

10x

D3456-1

D3456-1

Washer

D3533-1

D3533-1

Set Screw

November-28-11 9:05:11 AM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November-28-11 9:05:11 AM

Page 6

Work Order ID: 77185

77185

Parent Item: K10003

K10003

Parent Item Name: Saddle, D205-634-011

Start Date: 28/11/2011

Required Date: 12/12/2011

Start Qty: 5.00

Required Qty: 5.00

MS21042L4 ✓

Purchased

No

110

Each

10,709.00

24

120

MS21042L4

Nut

**

SP.

Location

Loc Qty

Loc Code

ST300

546

117441

51

117601

362

118451

133

ST516

5163

119017

5163

ST518

5000

119075

5000

120x

MS21043-4 ✓

Purchased

No

110

Each

1,453.000

5

25

MS21043-4

Nut

**

SP 11-12-06.

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1413

117793

5

118686

470

119309

438

119546

500

25x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST

Item	634 -011	634 -015	634 -041	634 -045	634 -045	Part Number	Description
	X					D205-634-011	SKIDTUBE INSTALLATION (STANDARD)
		X				D205-634-015	SKIDTUBE INSTALLATION (MODIFIED)
	1		X			D205-634-041	SKIDTUBE
		1		X		D205-634-045	SKIDTUBE
	1	1			X	D205-641-011	GROUND HANDLING KIT
1			1			D2580-041	205 SKIDTUBE ASSEMBLY (STANDARD)
1				1		D2580-045	205 SKIDTUBE ASSEMBLY (MODIFIED)
2A			16	16		D2594-1	* PLUG
2B			16	16		D2594-3	* O-RING
3			1	1		D2855	* AFT CAP
4			2	2		AN3-5A	* BOLT
5			2	2		NAS1149D0332J	* WASHER (AN960JD10L)
6A			1	1		D3564-9	* WEARSHOE (REPLACES D2577-1)
6B			1	1		D3566-1	* GASKET
7A			1	1		D3564-11	* WEARSHOE (REPLACES D2577-3)
7B			1	1		D3566-1	* GASKET
8A			1	1		D3564-5	* WEARSHOE (REPLACES D2577-5)
8B			1	1		D3566-5	* GASKET
9A			1	1		D3564-13	* WEARSHOE
9B			1	1		D3566-13	* GASKET
10			50	50		AN3C4A	* BOLT (REPLACES AN3-4A)
11			50	50		NAS1149C0332R	* WASHER (AN960C10L)
12			50	50		ALS4-1032-130	* INSERT
13			2	2		ALS4-1032-225	* INSERT
20	1	1				D2571	SADDLE, FWD OUTSIDE
21	1	1				D2572	SADDLE, FWD INSIDE
22	1	1				D2573	SADDLE, AFT OUTSIDE
23	1	1				D2574	SADDLE, AFT INSIDE
24	8	8				AN4-51A	BOLT
25	16	16				D2570	BUSHINGS
26	8	8				MS21042L4	NUT (OR MS21042-4)
27	8	8				AN6-12A	BOLT
28	8	8				NAS1149D0668J	WASHER (AN960JD616)
29	16	16				AN4-6A	BOLT
30	32	32				NAS1149D0463J	WASHER (AN960JD416)
31	16	16				MS21042L4	NUT (OR MS21042-4)
32	4	4				D2747	SET SCREW
33	2	2				D3533-1	SET SCREW
40	1	1				D3407-041	TOW RING (REPLACES D2968-041)
41	1	1				D3456-1	WASHER
43	1	1				MS21043-4	NUT
44	2	2				D3417-5	WASHER
50					1	D3405-041	LUG ASSEMBLY (REPLACES D2736-1)
51					1	D3405-043	LUG ASSEMBLY (REPLACES D2736-3)
52					4	AN4C46A	BOLT
53					8	D2570	BUSHING
54					4	MS21043-4	NUT (OR MS21042-4)
60	2	2				D2876	SADDLE SPACER
61	2	2				D2877	SADDLE SPACER

*DENOTES THAT PART IS INCLUDED WITH D2580-041/-045 ASSEMBLY ABOVE

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Revision: G

Date: 11.06.24

Work Order ID 77230

77230

Page 1

November-30-11 8:10:22 AM

Item ID: D2235-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Rib
 Start Date: 30/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 06/12/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: PL 3 Date: 11/11/30 Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2235	Rev B1								

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab 1- Pick D3166-1 and cut as per dwg D2235 using DT83022- remove identification markings on tube 3- deburr

Ac 11.12.12. (x10)

110 QC6- Inspect dimensions to drawing 0.00
110
 QC Memo 0.00
 Quality Control

Ac 11.12.12. (x10) Ø

120 Identify as per dwg & Stock Location: BC (WAS) 0.00
120
 Packaging Memo BASKET CELL 0.00
 Packaging

Ac 11.12.12. (x10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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